

Work Order ID 77945

77945

Page 1

December-23-11 10:24:22 AM

Item ID: D206-642-151

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 22/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 01/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/12/23

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3804	A
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IIN-D206-642	O
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100

0.00

100

DOCUMENT CONTROL

DC:

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number DescriptionBatch

A/R Aluminum Rod M119712/M119785 3BE12-01-20

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

12/1/19

DC 12/01/23

DC 12/01/23

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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Quality Control

Memo

0.00

8/12/11/23

①

DL 12/01/23

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Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

DK 12/01/23

12/01/23

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

DD

12-1-23

160

Skidtubes

0.00

160

Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D3804, (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

DK 12/01/23

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Cust Item ID:

Required Date: 01/02/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170 QC6- Inspect dimensions to drawing 0.00

170

QC

Memo

0.00

Quality Control

DP 12-1-23

180 0.00

180

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12

Hrs. cure time before cutting

Start Date: 12/01/23 Time: 4:50

Finish Date: 12/01/24 Time: 10:00

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 119558

Sikaflex expire date: 12/08/13

PC 12/01/23

Dart Aerospace Ltd

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Cust Item ID:

Required Date: 01/02/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

1 0 JE 12-01-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 22/12/2011 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 01/02/2012 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject / Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	--------------------	----------------

200

0.00

200

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch

A/RAluminum Rod M119785

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NOVE BE 12-01-25

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

BE 12-01-24BE 12-01-24DP 12-1-25

W/O:		WORK ORDER CHANGES					
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Required Date: 01/02/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210		0.00							
210	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	Install D2680-041 Nut Plate as per Dwg D3804								
215		0.00							
215	QC9- Inspect visual per QSI004- Fusion Welds								
QC	Memo	0.00							
Quality Control									
220		0.00							
220	QC10- Inspect visual per QSI004- ground welds								
QC	Memo	0.00							
Quality Control									

Handwritten: C, B, 12/01/24

Handwritten: 12.01.26

Handwritten: 12/01/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Required Date: 01/02/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00							
Quality Control									

240	Pressure Wash per QSI005 4.3	0.00							
240									
HandFinish	Memo	0.00							
Hand Finishing									

250	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
250									
Powdercoat	Memo	0.00							
Powder Coating									

START TIME: 2:20
 OVEN TEMPERATURE: 320
 FINISH TIME: 2:50

MUA480

① *[Signature]* CF 12-1-26
 IX *[Signature]* 12/01/26

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC3- Inspect Part Finish	0.00							
260									
QC	Memo	0.00							
Quality Control									
270		0.00							
270									
HandFinish	HandFinishing	0.00							
Hand Finishing	Memo								
	✓ I-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.								

W/O:		WORK ORDER CHANGES					
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Process Plan:

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Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

0.00

280

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

✓ A/RSikaflex-291 M119508

Sikaflex expire date: 12/08

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4

Batch: M1120125

1BH & M 12/02/15

290

QC3- Inspect Part Finish

0.00

290

QC

Memo

0.00

Quality Control

82/01/15

Dart Aerospace Ltd

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300

QC5- Inspect part completeness to step on W/O

0.00

300

QC

Memo

0.00

Quality Control

310

Packaging

0.00

310

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-151

Location: _____

PPP Rev: PPA 76705

320

QC21- Final Inspection - Work Order Release

0.00

320

QC

Memo

0.00

Quality Control

12-02-14
①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC
REV:B 11.09.16 PER IIN REV.O DD VERF:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2620

Manufactured

No

110

Each

13.0000

1

1

D2620

Skidtube, 206 Skidtube

**

Location

Loc Qty

Loc Code

LG

77997

13

71616

3

71617

6

75470

2

75587

2

① mo 12/1/19

D2647

Manufactured

No

110

Each

183.0000

1

1

D2647

Cap

**

Location

Loc Qty

Loc Code

LG002

183

73826

74

75482

109

BR 12/1/20

/

W/O:		WORK ORDER CHANGES					
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Picklist Print

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77945
D206-642-151

Start Date: 22/12/2011 Required Date: 01/02/2012
 Start Qty: 1.00 Required Qty: 1.00

CR3212-4-04 Purchased No 180 Each 12,557.00 52 52

CR3212-4-04
 Cherry Rivet

** OK 12/01/23

Location	Loc Qty	Loc Code
ST331	2567	
116471	78	
117816	3	
118686	1	
118840	16	
119017	2459	
119075	10	
st510	9990	(52)
119075	9990	

D2654-1 Manufactured No 180 Each 0.0000 1 1

D2654-1
 Web

** (1) OK 12/01/23

D3286-1 Manufactured No 180 Each 178.0000 2 2

D3286-1
 Doubler

** OK 12/01/23

Location	Loc Qty	Loc Code
LG002	178	(2)
74872	6	
75484	54	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-23-11 10:24:27 AM

Work Order ID: 77945

77945

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

200 Each

634.0000

19

19

D2649

Cross Bolt Spacer

**

BE 12-01-24
*B 78020 *19*

Location

Loc Qty

Loc Code

LG001

634

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

76793

515

D3286-3

Manufactured No

200 Each

18.0000

2

2

D3286-3

Spacer

**

BE 12-01-25
*B 76773 *2*

Location

Loc Qty

Loc Code

LG001

1

74117

1

LG002

17

75483

17

D2680-041

Manufactured No

210 Each

64.0000

1

1

D2680-041

Nut Plate

**

(1) BE 12/01/24

Location

Loc Qty

Loc Code

ST020

64

75479

64

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

December-23-11 10:24:27 AM

Page 4

Work Order ID: 77945

77945

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

210

Each

1,762.000

2

2

CR3212-4-03

Cherry Rivet

**

23 12/01/24

Location

Loc Qty

Loc Code

FP002

768

114859

768

ST331

994

110139

2

119017

992

AN960JD416

NAS1149D04631

Purchased

No

210

Each

0.0000

1

1

AN960JD416

Washer

**

1118384 (x1) 12/01/30

CCR264SS3-3

Purchased

No

210

Each

993.0000

2

2

CCR264SS3-3

Cherry Rivet

**

23 12/01/24

Location

Loc Qty

Loc Code

ST331

993

113973

2

117849

147

119017

844

MS27039-4-06

Purchased

No

210

Each

323.0000

1

1

MS27039-4-06

Screw

**

11 12/01/30

Location

Loc Qty

Loc Code

ST292

323

119075

323

xl

December-23-11 10:24:27 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

December-23-11 10:24:27 AM

Page 5

Work Order ID: 77945

77945

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2651-1	Manufactured	No	270	Each	357.0000	6	6
D2651-1							
Plug							

**

B77559(x6) JH 12/01/30

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	357	
57869	1	
66445	10	
69018	2	
70839	2	
71037	31	
73827	311	

D2651-3	Manufactured	No	270	Each	847.0000	6	6
D2651-3							
O-Ring							

**

JH 12/01/30

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	847	
61962	12	
73828	835	

X6

D3873-1	Manufactured	No	280	Each	611.0000	14	14
D3873-1							
Bushing							

**

B78017(x14) JH 12/01/30

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST088	611	
64760	1	
68247	4	
73829	19	
73830	2	
76792	585	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-23-11 10:24:27 AM

Page 6

Work Order ID: 77945

77945

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

280 Each

153.0000 1 1

D2646

Aft Cap

**

u 12/01/30

Location

Loc Qty

Loc Code

FP002

153

62678

5

68280

5

70945

1

71038

4

71070

2

73294

1

73825

135

X1

D3805-041

Manufactured No

280 Each

1.0000 1 1

D3805-041

Wearplate Assembly Fwd, Low Gear

**

B 76778 (x1) u 12/02/15

Location

Loc Qty

Loc Code

FP001

1

75149

1

MS27039-1-08

Purchased No

280 Each

1,243.000 2 2

MS27039-1-08

Screw

**

u 12/01/30

Location

Loc Qty

Loc Code

ST291

1243

117423

77

118910

226

119075

440

119109

500

X2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-23-11 10:24:27 AM

Page 7

Work Order ID: 77945

77945

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

280

Each

6,837.000

7

7

MS21042L3

Nut

**

12/01/30

Location

Loc Qty

Loc Code

ST300

6837

117441

16

117885

32

118451

5

118927

3

119017

5988

119075

793

X7

D3805-045

Manufactured

No

280

Each

2.0000

1

1

D3805-045

Wearplate Assembly Aft, Low Gear

**

12/02/07

Location

Loc Qty

Loc Code

FP001

2

73817

1

74896

1

AN960JD10L

NAS1149D0332J

Purchased

No

280

Each

0.0000

2

2

AN960JD10L

Washer

**

12/01/30

AN3-37A

Purchased

No

280

Each

1,546.000

7

7

AN3-37A

Bolt

**

12/01/30

Location

Loc Qty

Loc Code

ST353

1546

117619

4

119086

1542

X7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

December-23-11 10:24:27 AM

Page 8

Work Order ID: 77945

77945

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 22/12/2011

Required Date: 01/02/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

280

Each

2,252.000

7

7

NAS1149D0363.J

Washer

M 12/01/30

Location

Loc Qty

Loc Code

ST298

2252

117601

61

118077

1

118612

18

118968

137

119537

2035

x 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHO...
RE...
RE...
UNCONT...
SUBJECT TO...

NO. 77945 M.C.J
11/12/23

RELEASED
09.07.07
per ECN 09-538

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	91	PORT HADLOCK, WA	
CHECKED	91	DRAWING NO.	REV. A
MFG. APPR.	91	D3804	SHEET 1 OF 5
APPROVED	91	TITLE	SCALE
DE APPR.	91	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASE
09.03.03



DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	99	PORT HADLOCK, WA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	99	D3804	SHEET 2 OF 5
APPROVED	99	TITLE	SCALE
DE APPR.	99	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

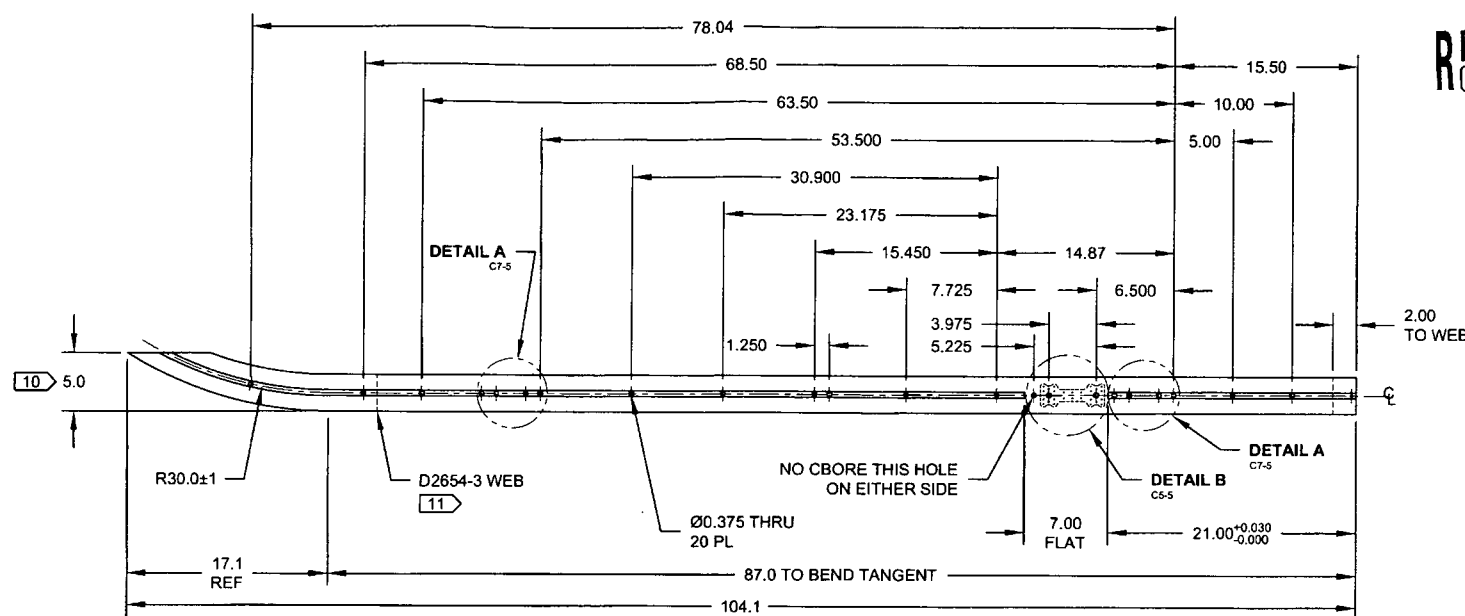
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

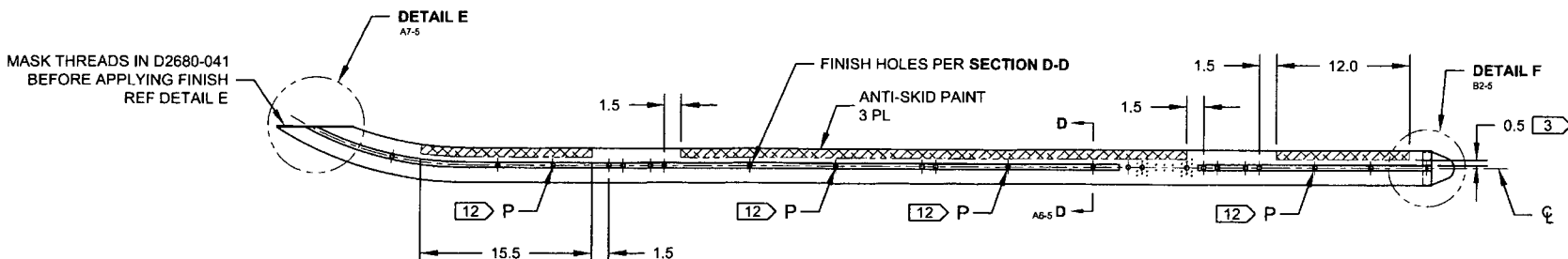
NOTE: Date & initial all entries

7745

RELEASED
09-03-07



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	41	DART AEROSPACE USA, INC	
DRAWN	5	PORT HADLOCK, WA	
CHECKED	6	DRAWING NO.	REV. A
MFG. APPR.	7	D3804	SHEET 3 OF 5
APPROVED	8	TITLE	SCALE
DE APPR.	9	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

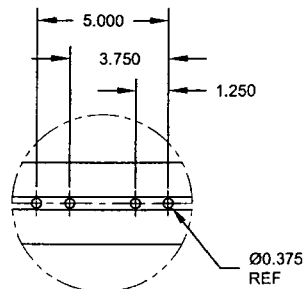
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

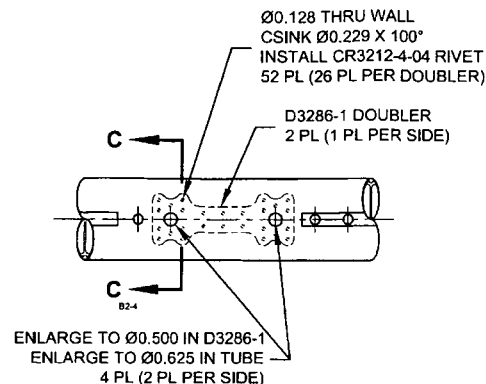
NOTE: Date & initial all entries

77945

RELEASED
UP 09.03.07

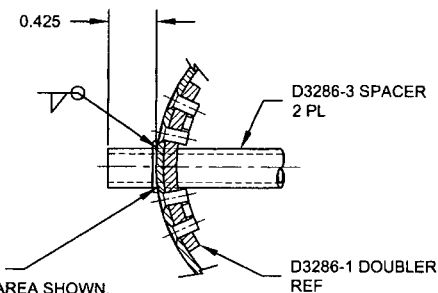


DETAIL A
SCALE NONE
D6-2
C2-2
D6-3
C2-3

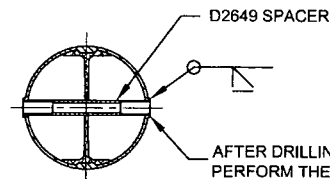


DETAIL B
SCALE NONE
C3-2
C3-3

- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH



SECTION C-C
PARTIAL SECTION
SCALE NONE
C6-4



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE
A4-2
A4-3

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	5	PORT HADLOCK, WA	
CHECKED	6	DRAWING NO.	REV. A
MFG. APPR.	8	D3804	SHEET 4 OF 5
APPROVED	10	TITLE	SCALE
DE APPR.	11	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

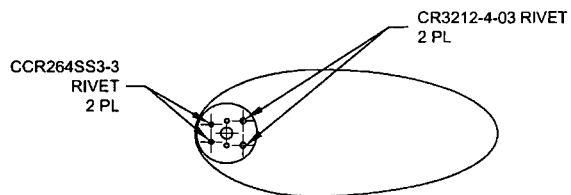
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

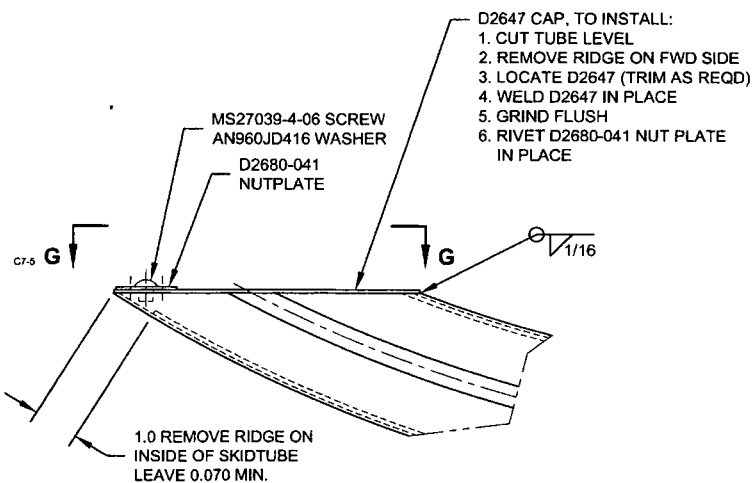
NOTE: Date & initial all entries

77945

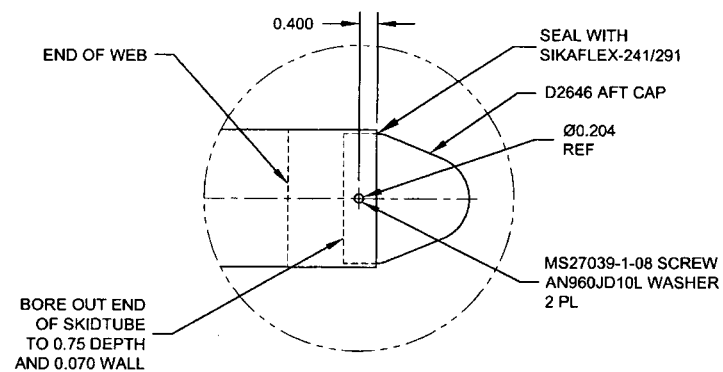
RELEASED
97 07 03 03



VIEW G-G
SCALE NONE A7-5



DETAIL E
SCALE NONE B7-2 B7-3



DETAIL F
SCALE NONE B2-2 B2-3

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	91	PORT HADLOCK, WA	
CHECKED	91	DRAWING NO.	REV. A
MFG. APPR.	91	D3804	SHEET 5 OF 5
APPROVED	91	TITLE	SCALE
DE APPR.	91	SKIDTUBE ASSEMBLY, 206A/B	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 281

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 77988
Part number: A206-642-151
Description: Skid plate
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Hume Date of Test Coupon 12.01.23
Welder Barclay Elliot Date of Test Coupon 12.01.23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld